

Date: Monday, 2/11/2008 11:37:48 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOUBLER	
Job Number	37309		Part Number	D3578041	
Estimate Number	12825		Drawing Number	D3578 REVA	
P.O. Number			Project Number	N/A	
This Issue	2/11/2008	S.O. No.	Drawing Revision	A	
Prsht Rev.	NC		Material		
First Issue	/ /	Type	Due Date	2/27/2008	Qty: 120
Previous Run	36340		Um:	Each	
Written By	<u>JH</u> 02/11				
Checked & Approved By					
Comment	Est: A 07.04.11 New issue EC				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S080	6061-T6 .080 Sheet 1
		Comment: Qty.: 0.0074 sf(s)/Unit Total : 0.4410 sf(s) 6061-T6 sheet 0.080" (M6061T6S080) Batch: <u>06320</u> HB 8-2-13
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3578 (Run prog. D3578-1) Dwg Rev: <u>A</u> HB 8-2-13 Prog Rev: <u>A</u>
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 8-2-13
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK 120
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 PFO
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Open rivet holes to 0.098" and C'sink as per dwg D3578

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/06	5	I piece contoured was too deep on the Human error.	/asian	Scrap & destroy	08/02/06	SIB 08/02/06	/asian	/asian

NOTE: Date & initial all entries

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Job Number: 37309		Part Number: D3578041
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		88 08/02/20 119
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		Fx 08/02/21
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		Mf 08/02/21
9.0	MS21075L3	Nutplate
Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s) Nutplate Batch: 15029 M106831 S4X		M107279 x 104 M106576 #5 S/P
10.0	MS20426AD33	Rivet
Comment: Qty.: 2.0000 Each(s)/Unit Total : 120.0000 Each(s) Rivet M 19099		8/2/21 50 60118
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		X119
1-Assemble as per dwg D3578		mlo8/03/04
12.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		QSP019 08/03/04 X119
13.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 247A		1-8/3/4 049

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
14.0	QC21 	FINAL INSPECTION/W/O RELEASE  <i>(119)</i>
Comment: FINAL INSPECTION/W/O RELEASE		<i>P 08/03/06</i>
Job Completion		 <i>2008/3/05</i> <i>(119)</i>

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37309
Description: Doubler	Part Number:	D3578-1
Inspection Dwg: D3578	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

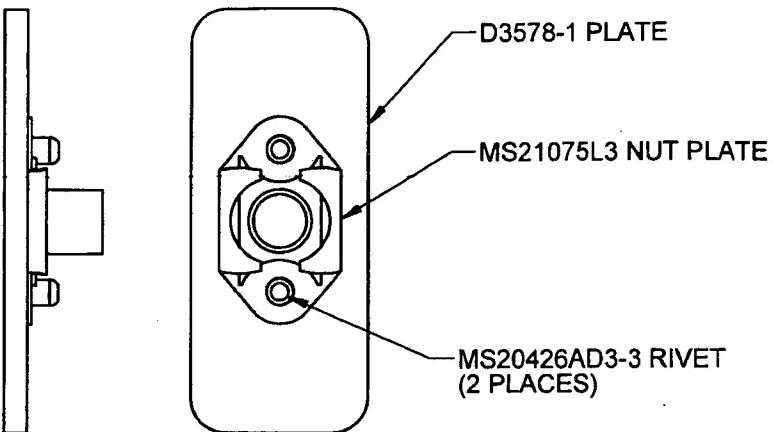
X First Article Prototype

Measured by:	<u>B</u>	Audited by:		Prototype Approval:	N/A
Date:	<u>8-2-13</u>	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	P/O D3578-041	KJ/EC/DD <i>[initials]</i> <i>[initials]</i>

DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>JB</i>	APPROVED <i>JH</i>	DRAWING NO. D3578	REV. A	SHEET 1 OF 1
DATE 07.01.12		TITLE DOUBLER	SCALE	3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE		



RELEASED
07.04.02

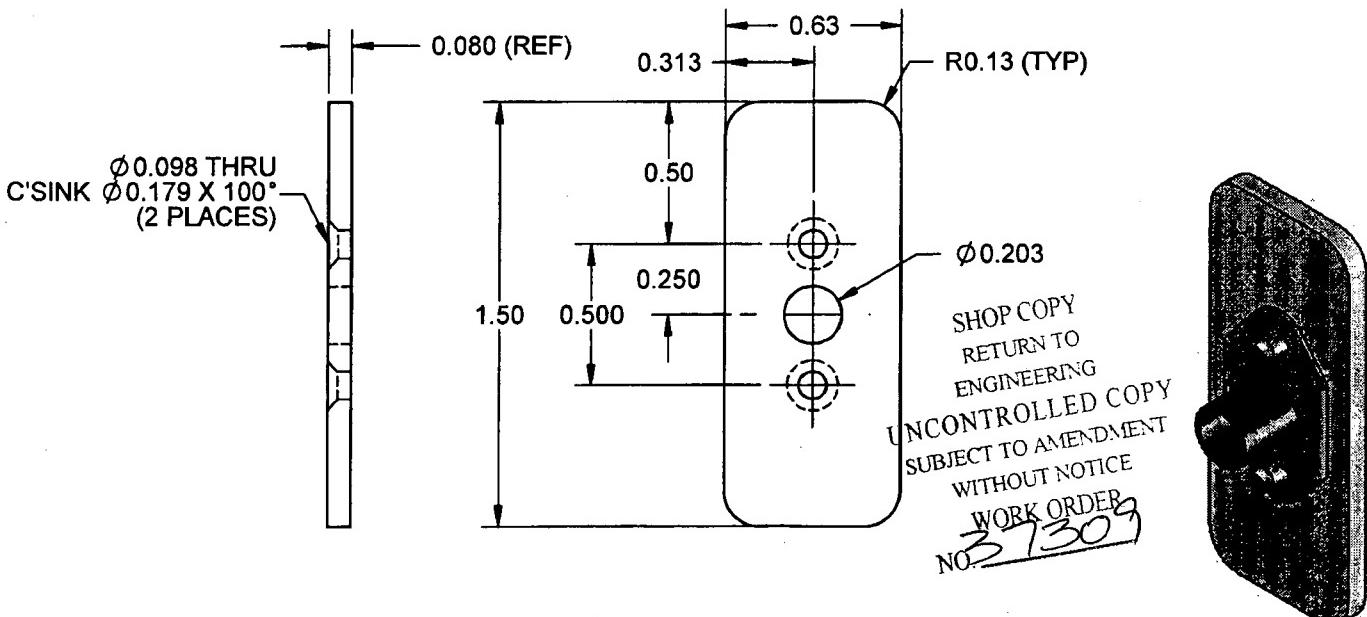
D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

D3578-041 NOTES:

- 1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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